



Dart Aerospace Ltd.
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D5134-042
Job Sheet 198272



W/ 197766

Part No: D5134-042

Job Qty: 4 pcs

Part Name: Damper Support Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs		9/2/19	0.00	0.16	Bandsaw - 1		W/ 19/9/21
110	HAAS 4 Axis - B4B	4 pcs		9/2/19	1.00	9.30	HAAS - 1 - B4B		W/ 19/9/21
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	4 pcs		9/2/19	0.00	0.00	QC 2 - 1		W/ 19/9/21
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



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Container No: S215795



Part: D5134-042

Job No: 198272

Serial No/Batch: S215795

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/21/19

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				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	4 pcs	9/2/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
135 Handfinish - 1-1 Chemical- B4B	4 pcs	9/2/19	0.00 0.40	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
137 QC 7	4 pcs	9/2/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	

mark 14/9/2019

SEP 23 2019

				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	DAS 41 SEP 23 2019
				QC 7 - 47	9-89
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
140	Spray Paint - 2 - B4B	4 pcs	9/2/19	0.00 0.67	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
150	QC 14	4 pcs	9/2/19	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 41
					QC 14 - 51
					QC 14 - 58
					QC 14 - 59
					QC 14 - 9
					QC 14 - 68
					QC 14 - 40
					QC 14 - 19
					QC 14 - 43
					QC 14 - 24
					QC 14 - 61
					QC 14 - 81
160	Small Fab - 2 - B4B	4 pcs	9/2/19	0.00 0.84	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
170	QC 5	4 pcs	9/2/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22

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					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
180	Packaging 3-1 - Stock - B4B	4	9/2/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC LG 054
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	4	9/2/19	0.00 0.00	QC 21 - SA - 21	DAS
	pcs				QC 21 - SA - 70	21 SEP 3 0 2019
					QC 21 - SA - 53	53
Part Op 100 - Bandsaw - CUT BLANK TO 5.125" LONG Descriptions: 110 - HAAS CNC Vertical Machine - Mill as per Dwg and folio FB342 DWG REV: <u>B</u> FOLIO REV: <u>AA</u> DEBURR 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 135 - Chemical Conversion Coat per QSI005 4.1 137 - QC7-Inspect Chemical Conversion Coat 140 - Spray Paint / NDT Room Pr: 5195271 Paint: 5204428						

- 150 - QC14- Inspect Spray Paint
 160 - Small Fab
 170 - QC5- Inspect part completeness to step on W/O
 180 - Identify as per dwg & Stock Location:
 190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B3.000X4.000	7075-T73 Bar 3.0 X 4.0 Grain Direction Along 3" (cut to 4 ft length)	1.7200 ft (.43 ea)	100-Bandsaw - 1	S206150
NAS77C6-021	Bushing	8 Ea (2 ea)	160-Small Fab - 2 - B4B	fm134833

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T73B3.000X4.000	2	3	0
160-Small Fab - 2 - B4B	NAS77C6-021	8	191	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Damper Support, RH	0.360Inches $\pm$ 0.030	0.390 0.330		,361
2	Damper Support, RH	0.188Inches $\pm$ 0.005 - 0.001	0.193 0.187		,188
3	Damper Support, RH	0.257Inches $\pm$ 0.006 - 0.001	0.263 0.256		,257
4	Damper Support, RH	1.932Inches $\pm$ 0.010	1.942 1.922		,932
5	Damper Support, RH	0.632Inches $\pm$ 0.010	0.642 0.622		,637
6	Damper Support, RH	0.632Inches $\pm$ 0.010	0.642 0.622		,636
7	Damper Support, RH	0.730Inches $\pm$ 0.010	0.740 0.720		,730
8	Damper Support, RH	0.500Inches $\pm$ 0.000 - 0.001	0.500 0.499		,4995
9	Damper Support, RH	0.100Inches $\pm$ 0.010	0.110 0.090		,101
10	Damper Support, RH	0.728Inches $\pm$ 0.010	0.738 0.718		,726
11	Damper Support, RH	0.250Inches $\pm$ 0.030	0.280 0.220	Radius	
12	Damper Support, RH	0.630Degrees $\pm$ 0.030	0.660 0.600	Radius	
13	Damper Support, RH	0.063Degrees $\pm$ 0.010	0.073 0.053	Radius	
14	Damper Support, RH	0.117Inches $\pm$ 0.010	0.127 0.107		,112
15	Damper Support, RH	0.177Inches $\pm$ 0.010	0.187 0.167		,178
16	Damper Support, RH	0.841Inches $\pm$ 0.010	0.851 0.831		,841
17	Damper Support, RH	0.208Inches $\pm$ 0.010	0.218 0.198		,206
18	Damper Support, RH	0Degrees $\pm$ 0	0 0		0°
19	Damper Support, RH	0.860Inches $\pm$ 0.010	0.870 0.850		,864
20	Damper Support, RH	1.471Inches $\pm$ 0.010	1.481 1.461		,1472
21	Damper Support, RH	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	,125

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐
					Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042) _____	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				